

Date: Monday, 2/5/2007 8:06:47 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 13-MAN SHOULDER HARNESS KIT
Job Number	: 30590		
Estimate Number	: 11863		
P.O. Number	: N/A	Part Number	: D412702011
This Issue	: 2/5/2007	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C
Previous Run	: 29117	Material	: N/A
	Type : PURCHASED PARTS	Due Date	: 3/10/2007
Written By	:	Qty:	3 Um: Each
Checked & Approved By	:		
Comment	: Est.Rev:A 03.10.17 New issue KJ/RF Est Rev:B 06.04.03 As per DSI9324 JLM est rev C 06.12.14 per ecn871 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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KS 01-02-13

Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD412-702-011 CHG001

CHG002 Rev DSI 9351

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D3195041	Bracket Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bracket Assembly

Qty Part Number Description Batch

2 D3195-041 Bracket

B27840 (4x) B30653 (2x) B31272 (x2)

4.0	D3195043	Bracket Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bracket Assembly

Qty Part Number Description Batch

2 D3195-043 Bracket

B27841 (6x) B31573 (2x)

5.0	D31961	Bar
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bar

Qty Part Number Description Batch

1 D3196-1 Bar

B32146 B31466 3x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Part Number: D412702011

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D31963

Bar



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bar

Qty Part Number Description Batch

1 D3196-3 Bar

B30602 ✓

7.0

D31964

Bar



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Qty Part Number Description Batch

Bar

1 D3196-4 Bar

B29965 ✓

8.0

D3197041

Bar Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bar Assembly

Qty Part Number Description Batch

2 D3197-041 Bar

B30603 ✓

9.0

D31981

Fitting



Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~20.0000~~ Each(s)

Fitting

Qty Part Number Description Batch

4 D3198-1 Fitting

30147 ✓

10.0

D3215041

Harness Assembly



Comment: Qty.: 18.0000 Each(s)/Unit Total: 90.0000 Each(s)

Harness Assembly

Qty Part Number Description Batch

18 D3215-041 Harness Assembly

B30605 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D412702011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D3215043

Harness Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total: ¹²~~20~~.0000 Each(s)

Harness Assembly

Qty Part Number Description Batch

4 D3215-043 Harness Assembly *B 30606 ✓ ✓*

12.0

AN45A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: ¹²~~20~~.0000 Each(s)

Bolt

Qty Part Number Description Batch

4 AN4-5A Bolt *M100857- ✓*

13.0

AN413A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: ¹²~~20~~.0000 Each(s)

Bolt

Qty Part Number Description Batch

4 AN4-13A Bolt *M103363 ✓*

14.0

AN420A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: ³²~~40~~.0000 Each(s)

Bolt

Qty Part Number Description Batch

8 AN4-20A Bolt *M16895- (32) ✓*

15.0

AN960JD416

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total: ⁶⁰~~100~~.0000 Each(s)

Washer

Qty Part Number Description Batch

20 AN960JD416 Washer *M103338 ✓*

16.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: ³⁶~~60~~.0000 Each(s)

Nut

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4) *M103349 32 X- M103917 (40) ✓*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 1 Date: 07/04/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Seq. #:

Machine Or Operation:

Description:

17.0

MS24694S152

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)
Screw

Qty Part Number Description Batch

8 MS24694-S152 Screw M101124 - ✓

18.0

MS24694S154

SCREW



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

SCREW

Batch: M1030924 ✓

7/03/21 SD

19.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C207/04/23 (3)

7/4/23 (3)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-011

Location:

PPP Rev: B

7/4/23 (3)

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/04/23
U of 04-23

Job Completion



182

2x D3546-1 ✓

B-29766

6

13x D3551-11

B-27558
B31217 39X

B-28798
B-31217 (3)

per DSE 9351

7/03/22 SD

W/O:		WORK ORDER CHANGES					
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QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries